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D4775-041
Job Sheet 178140



Part No: D4775-041

Job Qty: 5 ea **DAS**
21
9-89

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/27/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Stores/Pkg-1	DAS	JUL 19 2018
110	Packaging	5 pcs	6/8/18	6/8/18	0.00	0.00	Packaging1-5	5	AUG 21 2018
120	Small Fab	5 pcs	6/8/18	6/8/18	0.00	2.07	Small Fab-7	1-89	DAS
130	QC	5 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
140	Packaging	5 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-2	St37	DAS
150	QC21-SA	5 Ea	6/8/18	6/8/18	0.00	0.00	QC21	6	AUG 24 2018

Part Op 120 - 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
Descriptions: BATCH: _____ 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A	Bolt	12 10 Ea (2 ea)	90-Start up Operation	5078251
D4775-1	Strut Tube	6 5 Ea (1 ea)	90-Start up Operation	5083573
D4776-1	Basket Strut Clevis	6 5 Ea (1 ea)	90-Start up Operation	5090394x1 5090388 x5
D4776-5	Spacer	27 20 Ea (4 ea)	90-Start up Operation	5090210x12
D4777-1	Rod End Bearing	6 5 Ea (1 ea)	90-Start up Operation	5084049
MS21042L3	Nut	12 10 Ea (2 ea)	90-Start up Operation	5078162
MS21209-F615	Heli-Coil	6 5 Ea (1 ea)	90-Start up Operation	5073806

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-10A	12 10	126	0
	D4775-1	6 5	21	0
	D4776-1	6 5	8	0
	D4776-5	27 20	80	0
	D4777-1	6 5	30	0
	MS21042L3	12 10	1,322	0
	MS21209-F615	6 5	123	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Suspected Unapproved		Rework Scrap Use-as-is		Skid-tube Machining Thermoforming Large Fab		Cross tube Small Fab Finishing Composite	
Water Jet		Prod. Eng. Coord.		Rec/Store/Packaging		Supplier	
Engineering		Quality		Other			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation				Disposition			
Completed By				Lead hand / Supervisor Approval Verification			
QC / QA Coordinator Approval							

Container No: S093530
Part: D4775 - 041
Job No: 178140
Serial No/Batch: S093530
Revision:
Inspector:
Exp Date:
Instructions:

Root Cause		Pressure/Forced		Positioned Wrong	
Environment	No Re-verification	Bending	Folio/Program	Outside Dimensions	
Design	Operator	Centre Not Concentric	Grain	Over/Under tolerance	
Doc/Data	Offset/Setup	Cracks	Weld	Part Incorrect	
Equip/Tooling	Supplier	Crimp/Kink/Ripple/Wave	Wrong Stock Pulled	Part Lost/Missing	
Handling/Pre	Training	Cuffs	Out of Sequence	Part Moved	
Material	Use for Testing	Crushing	Off-set	Drawing	
Internal Transport	Poor Information	Heat Treat	Mislabeled	Finish	
Tribal Knowledge	Rushing	Wave/Twist in Tube	Fit/Function	Misread	
LOA	Product Improvement	Marks/Chatter	Misaligned/off center	Turning Sequence	
Substation	Process Improvement				
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due				
OTHER :					